

Work Order ID 110044

December-17-13 9:06:52 AM

110044

Page 1

Item ID: D3017-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Back
 Start Date: 12/19/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/19/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: PP Date: 12-17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3017	Rev B

100 Weld per dwg A/R 4130 rod Batch: M118875 0.00
100 Large Fab 1 EL 14-1-8
 Memo 0.00
 1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017
 2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)
 3-Drill holes in D3017-5 Using DT8622
 4-Deburr
 5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598
 6-Drill holes in back frame using DT8621

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 QC Memo 0.00 ① 14-01-08 **DAS**
 Quality Control **9**
989

Work Order ID 110044

December-17-13 9:06:52 AM

110044

Page 2

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 Required Date: 12/19/13 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									DAS
QC	Memo	0.00				①	14-01-08		9-89
Quality Control									
130	Grey Sandtex(Ref:4.3.5/6) per QSI005 4.3	0.00							
130									DAS
Powdercoat	Memo	0.00				1	Φ	14-1-9	34
Powder Coating	START TIME: 1:00 OVEN TEMPERATURE: 320° FINISH TIME: 1:30								9-89
140	QC3- Inspect Part Finish	0.00							
140									DAS
QC	Memo	0.00				1X			36
Quality Control									9-89

12/01/09

December-17-13 9:06:52 AM

1 10044

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Seat Back

Start Date: 12/19/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/19/13 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number**Insp.
Stamp**

150

Identify as per dwg & Stock Location: GA

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

IX 14/01/08

14-01-10

14-01-09

PL 14-01-16

DAS
36
J-89

Picklist Print

December-17-13 9:06:51 AM

Page 1

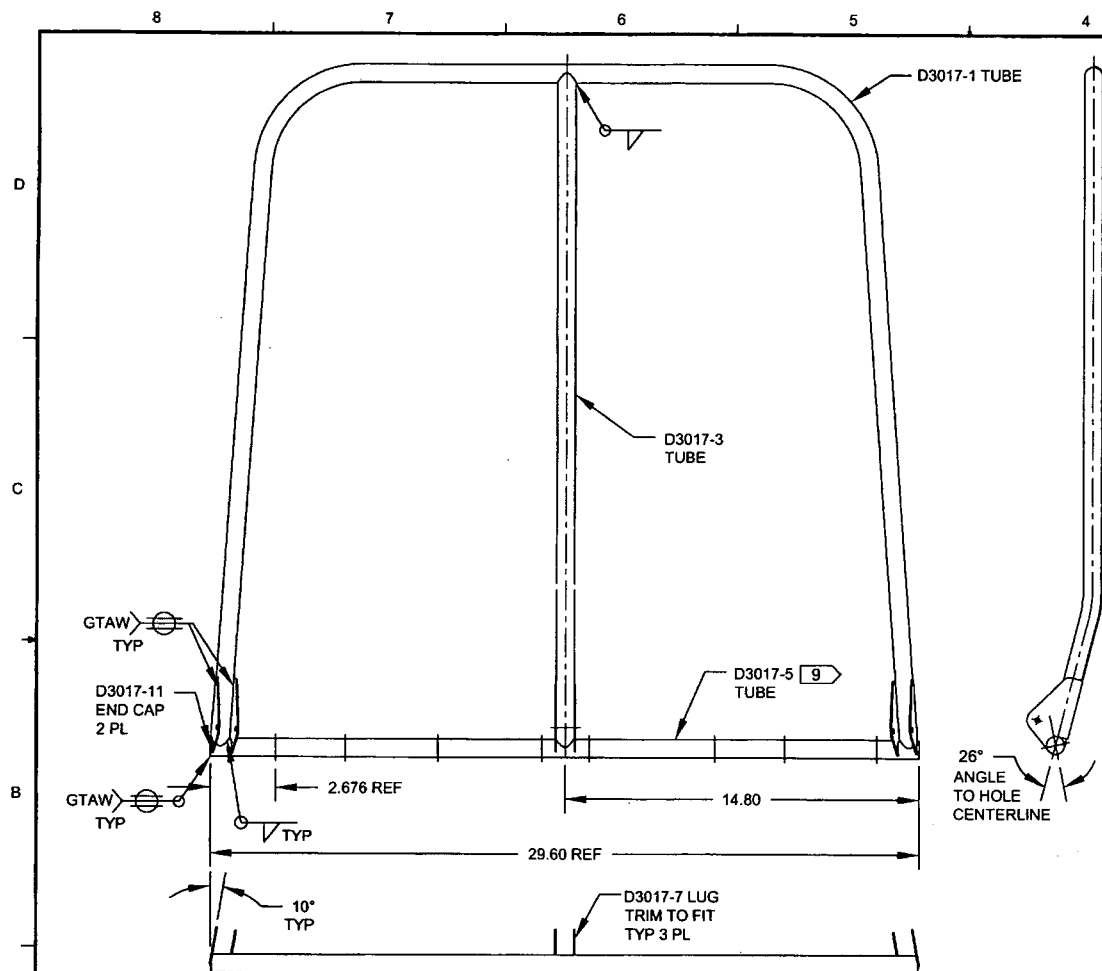
Work Order ID: 110044
Parent Item: D3017-041
Parent Item Name: Seat Back

Start Date: 12/19/13 Required Date: 12/19/13
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083 4130 RD Tube .750 x.083W		Purchased	No			100	f	38.6700	2.458	3 13-12-30			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		38.67							
				m126545		2							
				m127493		36.67			2.5				
M4130NT0.750W.049 4130 RD Tube .750 x.049W		Purchased	No			100	f	216.2952	11.125	12 13-12-30			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		216.2951893							
				123339		2.1217893							
				125252		7.7164							
				125313		85.284							
				m127111		121.173			9				
D3017-11 Cap		Manufactured	No			100	Each	51.0000	2	2 14-1-8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		51							
				104954		30			2				
				106668		21							
D3017-7 Lug		Manufactured	No			100	Each	20.0000	3	3 13-12-30			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA001		9							
				100996		9			3				
				WA002		11							
				105568		11							

Dr



ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

110044
R13-1217

RELEASED
R 2010-02-02
wp

D3017-041 BACK FRAME ASSEMBLY

NOTES:

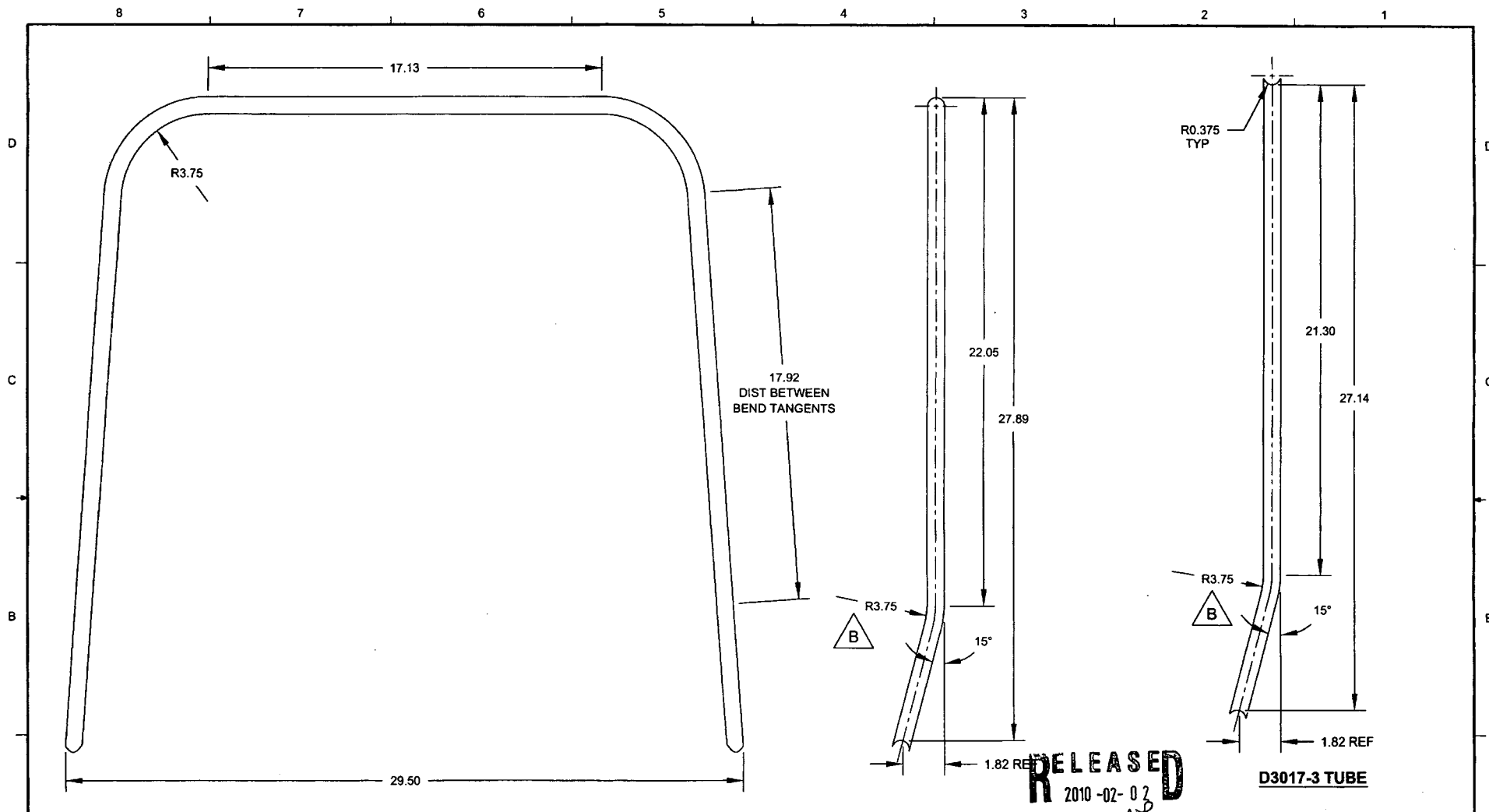
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

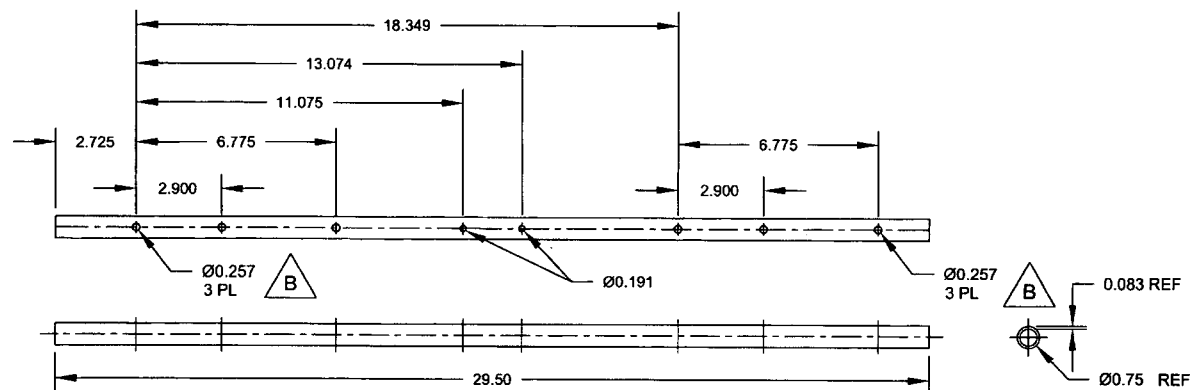
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RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3017-1: 2.38 lbs; D3017-3: 0.84 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
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D3017-5 TUBE

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2010-02-02

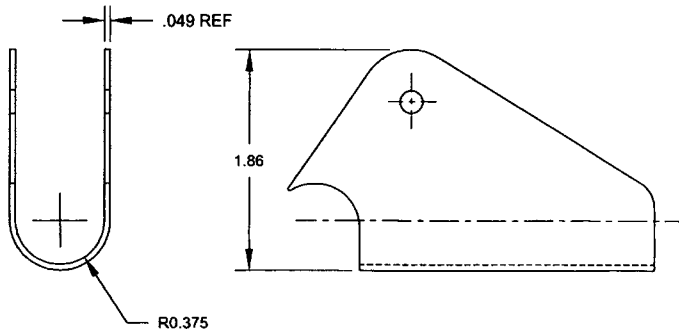
NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs

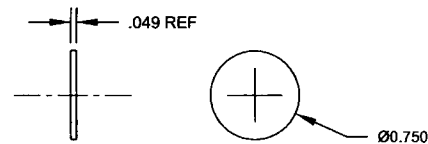


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MFG. APPR.		D3017	SHEET 3 OF 4
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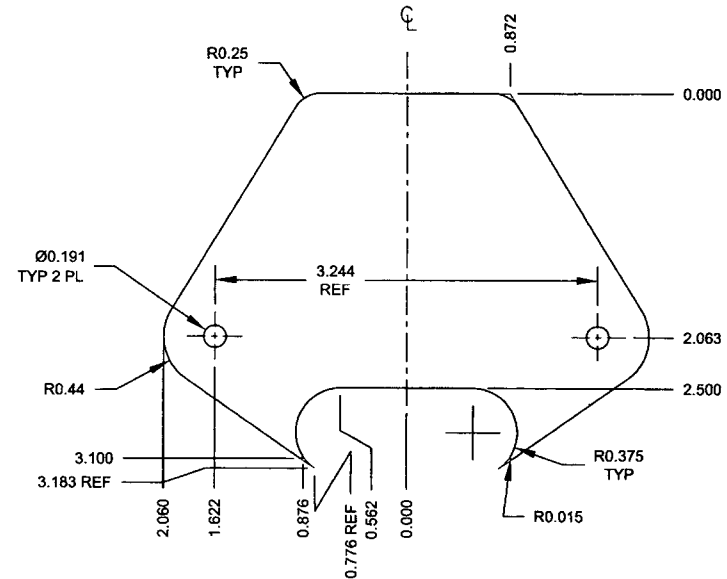
8 7 6 5 4 3 2 1



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

